Work Order ID 67609

Monday, March 28, 2011 2:29:38 PM

Item ID: D3296-041 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Door Assembly

Start Date: 3/28/2011 **Start Qty:** 6.00 **Cust Item ID:**

Required Date: 3/31/2011 **Req'd Qty:** 6.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** N **Date:** 11-03-28 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3296	Rev A								
100		0.00							
Small Fab	Small Fab								
Small Fab	**Memo**	0.00							
Small Fab	Fabricate & assemble as per Dwg D3296.								
	Tranfer drill using DT8470 & DT9521								
110	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control									
120	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
Powdercoat	**Memo**	0.00							
Powder Coating	START TIME: 11:15 ☐OVEN TEMPERATURE: 320°F ☐FINISH TIME: 11:45								

S 11/05/09

(6) 11/05/09 (6)

(+6)

6x Ø M 11/05/10

M115128

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

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Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC3- Inspect Part Finish	0.00							
QC	**Memo**	0.00				6	PR	11-5-10.	
Quality Control									
140		0.00							
Small Fab	Small Fab								
Small Fab	**Memo** Assemble as per Dwg D3296	0.00					11/05/11	6	
150	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00				6			
Quality Control									

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: 218	0.00							
Packaging	Memo	0.00				11/5/11		60	
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00					11/5/12		
QC	Memo	0.00							
Quality Control									

MK
11-05-12

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Picklist Print

Monday, March 28, 2011 2:29:44 PM

Work Order ID: 67609

Parent Item: D3296-041

Parent Item Name: Door Assembly

Start Date: 3/28/2011 **Required Date:** 3/31/2011

Start Qty: 6.00 **Required Qty:** 6.00

Comments: IPP C□05.10.14□Added step 14□KJ/EC□
IPP Rev:D Revised Steps 06-11-20 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3161-7		Manufactured	No			100	Each	0.0000	1	6			
Hinge 14.0"							B68487						
D3161-9		Manufactured	No			100	Each	2.0000	1	6			
Hinge 17.0"													
				Location			**Loc Qty**		**Loc Code**				
				ST037			2						
					65098		2			2			
D3296-1		Manufactured	No			100	Each	8.0000	1	6			
Door Panel													
				Location			**Loc Qty**		**Loc Code**				
				ST186			8						
					65083		2			2			
					66192		6			4			
D3296-3		Manufactured	No			100	Each	6.0000	1	6			
Door Panel													
				Location			**Loc Qty**		**Loc Code**				
				ST196			6						
					66191		6			6			

11/05/11

11/05/11

B68894 (4x)

11/05/11

11/05/11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

Monday, March 28, 2011 2:29:44 PM

Work Order ID: 67609

Parent Item: D3296-041

Parent Item Name: Door Assembly

Start Date: 3/28/2011 **Required Date:** 3/31/2011

Start Qty: 6.00 **Required Qty:** 6.00

MS20470AD4-6		Purchased	No	100	Each	1,762.000	1	6	11/05/11
Rivet, Universal Head									
	Location		**Loc Qty**	**Loc Code**					
	ST319		1762						
		116391	1762					6	
AN960JD6	NAS1149DN632J	Purchased	No	140	Each	245.0000	1	6	11/05/11
Washer									
	Location		**Loc Qty**	**Loc Code**					
	ST347		245						
		104537	245						
D2137		Manufactured	No	140	Each	11.0000	1	6	11/05/11
Decal - No Step									
	Location		**Loc Qty**	**Loc Code**					
	GA		11						368923 (6x)
		62071	10						
		65121	1						
D2419		Manufactured	No	140	Each	1.0000	1	6	11/05/11
Handle									
	Location		**Loc Qty**	**Loc Code**					B68896 (6x)
	GA		1						
		63423	1						
D2462		Manufactured	No	140	f	480.0000	0.3333	1.9998	11/05/11
Seal									
	Location		**Loc Qty**	**Loc Code**					
	ST404		480						
		48530	480						1.9998

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

Monday, March 28, 2011 2:29:45 PM

Work Order ID: 67609

Parent Item: D3296-041

Parent Item Name: Door Assembly

Start Date: 3/28/2011 **Required Date:** 3/31/2011

Start Qty: 6.00 **Required Qty:** 6.00

D2728-1 Dart Logo label	Manufactured	No	140	Each	0.0000	0	0	11/05/11
MS20470AD4-4 Rivet, Universal Head	Purchased	No	140	Each	2,678.000	25	150	11/05/11

Location		Loc Qty	Loc Code
ST319		2678	
	116188	2317	150
	116391	361	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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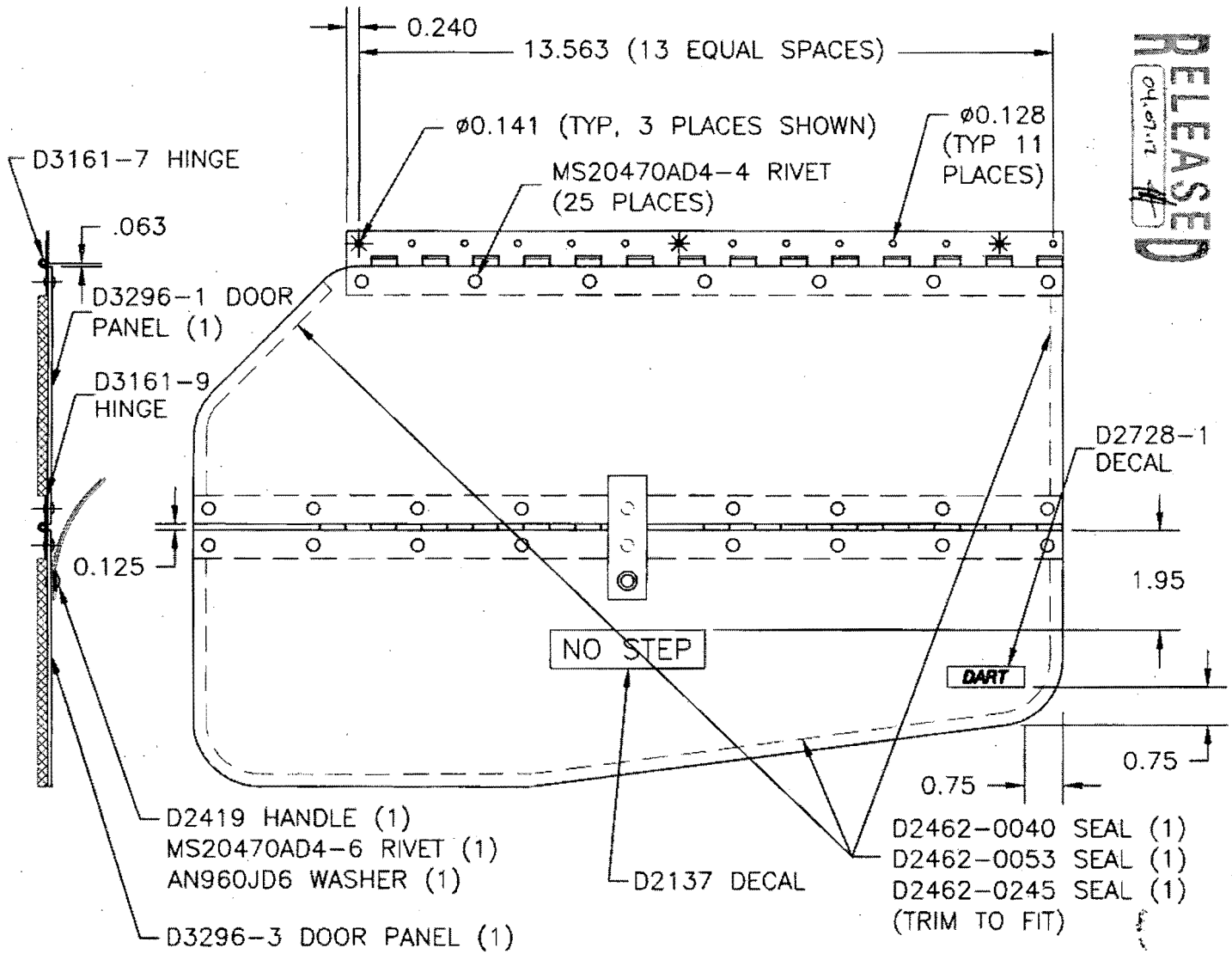

D3296-041 DOOR ASSEMBLY

1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED 04.07.12

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WITHIN ORDER NO. 67609 11-03-28

CA COPY ISSUED

DESIGN	DRAWN BY	DRAWING NO. D3296	REV. A
CHECKED	APPROVED	TITLE DOOR ASSEMBLY	1 OF 2
DATE 04.06.28			SCALE 1:3

A	04.06.28	NEW ISSUE

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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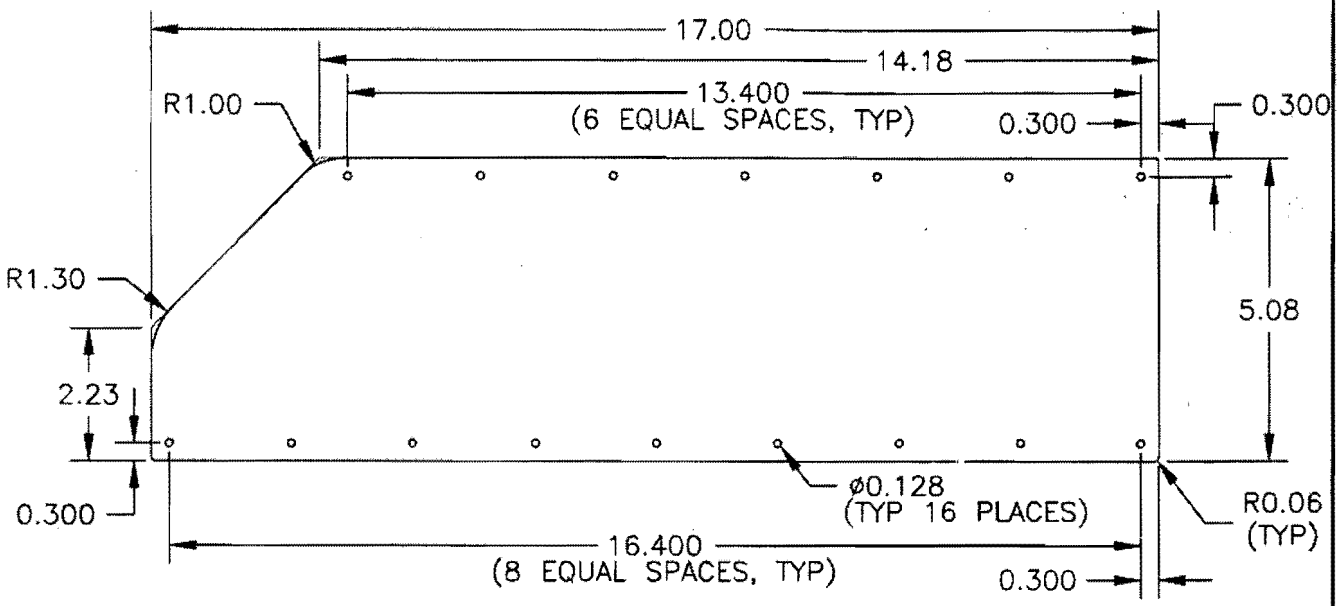
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

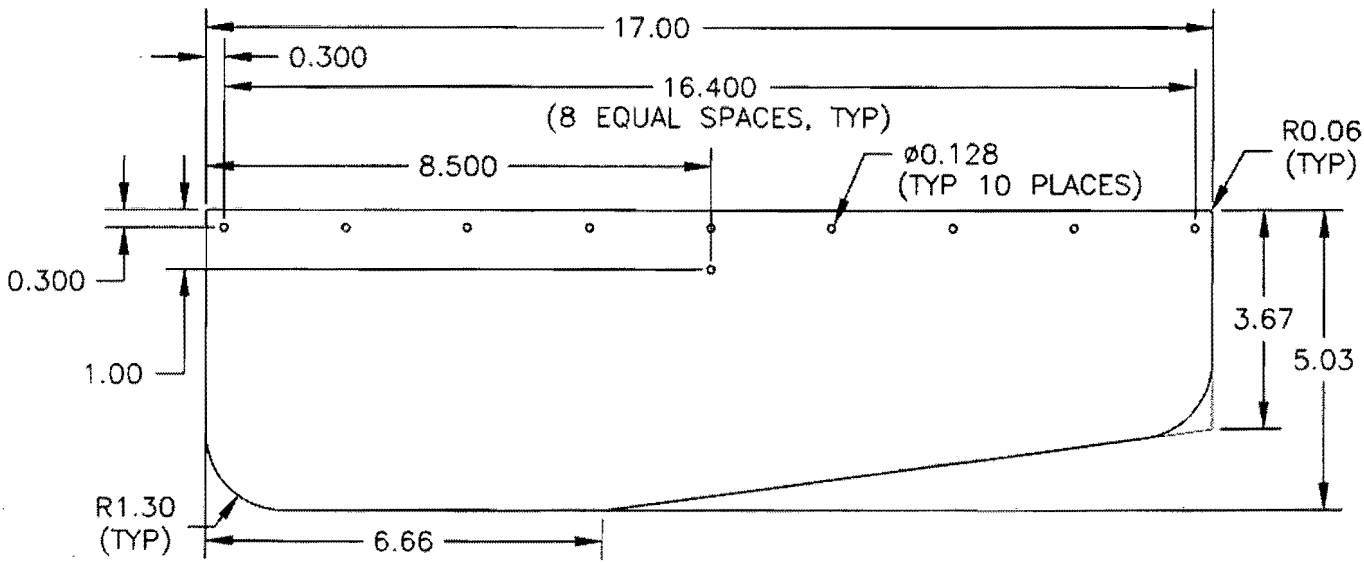
H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

w/067609

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3296	REV. A 2 OF 2
DATE 04.06.28		TITLE DOOR ASSEMBLY	SCALE 1:3



D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

RELEASED 04.07.12

D3296-1 AND D3296-3

1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
(REF DART SPEC. M2024T3S.063)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries